

Work Order ID 73830

Friday, September 16, 2011 11:42:58 AM



Page 1

Item ID: D3873-1

Accept



Setup Start



Revision ID:

Item Name: Bushing

Stop



Start Date: 9/16/2011 Start Qty: 400.00



Cust Item ID:

Required Date: 10/7/2011 Req'd Qty: 400.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3873	B								

100

0.00



Hardinge

0.00

Hardinge CNC Lathe Small

Memo

1-TURN AS PER FOLIO-FA806 & DWG D3873,

FOLIO REV: N/A

DWG REV: 13

2-DEBURR AS REQUIRED

[Signature] 11/10/21

400

0

[Signature] 11/10/21

110

0.00



QC

0.00

Quality Control

Memo

QC2- Inspect parts off machine FAI/FAIB

[Signature] 11/10/21

400

0

[Signature] 11/10/21

Dart Aerospace Ltd

WORK ORDER CHANGES

W/O:		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
DATE	STEP						

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

WORK ORDER NON-CONFORMANCE (NCR)

NCR:		Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
DATE	STEP		Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Revision ID:

Stop



Item Name: Bushing

Start Date: 9/16/2011 Start Qty: 400.00



Cust Item ID:

Required Date: 10/7/2011 Req'd Qty: 400.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

11/10/21

400

0

Quality Control

130

Identify as per dwg & Stock Location: ~~18~~ 88

0.00



Packaging

Memo

0.00

Packaging

11/10/21 400

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/10/24

mf 11-10-24

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Friday, September 16, 2011 11:42:56 AM

Page 1

Work Order ID: 73830



Parent Item: D3873-1



Parent Item Name: Bushing


Start Date: 9/16/2011

Required Date: 10/7/2011

Start Qty: 400.00

Required Qty: 400.00

Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M303R0.625 		Purchased	No			100	f	15.2000	0.06	25.26316		<i>SL 11/10/21</i>	
303 Round Bar 0.625"													

Location

Loc Qty

Loc Code

MAT028

15.2

110167

3.2

118400

12

119009

23.333

12 RT
+ 4 RT
1 FT

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____



NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

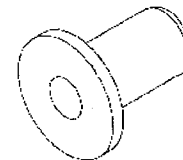
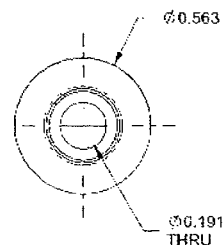
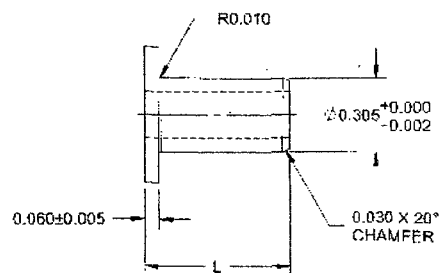
DART AEROSPACE LTD		Work Order:	
Description: Bushing		Part Number:	D3873-1
Inspection Dwg: D3873 Rev: B			Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

[illegible]

Measured by: 	Audited by: 	Preliminary Approval:
Date: 4/10/19	Date: 4/10/21	Date:

Rev	Date	Change	Revised by	Approved
A	09.05.20	New Issue	KJ	
B	10.11.05	Dimensions updated per Dwg Rev B	KJ	



D3873-X BUSHING



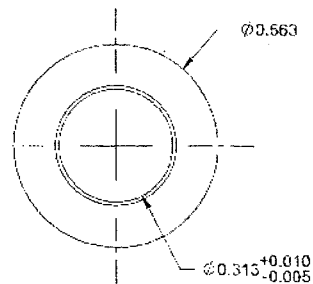
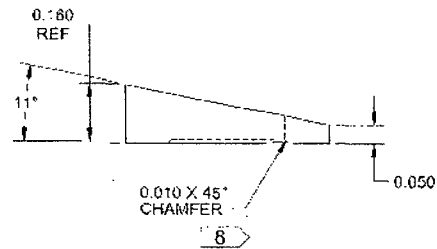
DART P/N	L	WEIGHT (lbs)
D3873-1	0.600	0.010
D3873-3	0.120	0.005
D3873-5	0.270	0.007

RELEASED
2011-06-12

NOTES:

- 1) MATERIAL: AISI 303 STAINLESS STEEL ROUND BAR PER ASTM A582
REF DART SPEC M303R
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: PER TABLE

C	ADD D3873-3/-5/-7 (ZN BG-1 & BG-2)	RF	11.06.14
B	Ø0.562 WAS Ø0.563 (C3 1, TO FIT TRIBAC GIRT)	CP	10.07.22
A	NEW ISSUE	MS	09.01.07
REV.	DESCRIPTION	BY	DATE
DESIGN	CP	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
DRAWN	SC		
CHECKED	CP	DRAWING NO.	REV. C
MFG. APPR.	CP	D3873	SHEET 1 OF 2
APPROVED	CP	TITLE	SCALE
DE APPR.	CP	BUSHING	NTS
DATE	11.06.14	COPYRIGHT © 2009 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS UNCLASSIFIED UNLESS INDICATED OTHERWISE. IT IS TO BE RELEASED TO THE PUBLIC OR COUNTRIES OF ALLIED NATIONS BY AUTHORITY OF THE SECRETARY OF DEFENSE. REF ID: A66666	



C D3873-7 SPACER



NOTES:

- 1) MATERIAL: AISI 303 STAINLESS STEEL ROUND BAR PER ASTM A582
REF DART SPEC M303R
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.005 lbs
- 8) IT IS ACCEPTABLE TO BE DEBURR

DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	PORT HADLOCK, WA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>[Signature]</i>	D3873	SHEET 2 OF 2
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	BUSHING	NTS
DATE	11.06.14	<small>COPYRIGHT © 2009 BY DART AEROSPACE USA, INC. THIS DRAWING IS THE PROPERTY OF DART AEROSPACE USA, INC. AND IS NOT TO BE REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS, ELECTRONIC OR MECHANICAL, WITHOUT PERMISSION IN WRITING FROM DART AEROSPACE USA, INC.</small>	

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2011-09-12
[Signature]